

Work Order ID 55338

January 13, 2010 10:26:37 AM

Page 1

Item ID: D3205-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Pedal Bracket

Start Date: 1/13/10 Start Qty: 6.00

Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan: *R*

Date: 10-1-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3205

Rev A

100

0.00



Bandsaw

BAND SAW

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)

mk 10/01/16

6 6 6

110

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3205-1 as per Folio FA346 and Dwg D3205 Identify as D3205-1

Deburr and Tumble

mk 10/01/17

6 1

PTO

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

mk 10/01/17
mk 10-01-18

6 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3205-1 PAR #: N/A Fault Category: Mach. Dr NCR: (Yes) No DQA: A Date: 10.01.22
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: X Date: 10/01/26

NCR: <u>55338</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/01/16</u>	<u>110</u>	<u>1 part scrap, the 1/4 rad are too small.</u> <u>R.C. he have #2 1/4 rad cutter with 2 different bps size.</u>	<u>[Signature]</u> <u>02/01/22</u>	<u>destroy and replace</u> <u>Qty 1 Batch <u>17102694</u></u> <u>Fix Polio</u>	<u>[Signature]</u> <u>10/01/17</u> <u>[Signature]</u> <u>10.01.22</u>	<u>S</u> <u>10/01/16</u> <u>10.01.22</u>	<u>[Signature]</u> <u>02/01/22</u>	<u>S</u> <u>10/01/18</u>

NOTE: Date & initial all entries

Work Order ID 55338



Page 2

January 13, 2010 10:26:37 AM

Item ID: D3205-1

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Item Name: Pedal Bracket

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Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

LA 10/01/10

6 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

M 10/01/10

(X6) 0

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

M112588

=> M 10/01/10

(X6) 0

Note: Cover the thread hole for D3205-1 before powder coat. START
TIME: 6:45 AM OVEN TEMPERATURE:
7:15 AM FINISH TIME: 320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55338

January 13, 2010 10:26:37 AM

Page 3

Item ID: D3205-1

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Setup Start

Revision ID:

Stop

Item Name: Pedal Bracket

Start Date: 1/13/10 Start Qty: 6.00

Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date:

Tooling: Date:

Stop

QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

BR 10-01-21 @

170

Identify as per dwg & Stock Location: 197

0.00

Packaging

Memo

0.00

Packaging

10-1-21 @ SP

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/22 df
MF 10-1-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 13, 2010 10:26:41 AM

Page 1

Work Order ID: 55338



Parent Item: D3205-1



Parent Item Name: Pedal Bracket

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP A 04.06.09 [] New issue [] KJ/RFL []
IPP Rev: B 08-12-16 attach DEO DD verified by: EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2		Purchased	No			100	f	6.0167	2.3027			

5



7075-T73 Bar 2.50 x 3.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

6.0167

102694

1.6

112331

4.4167

m7075

7075-T73

2.50 X 3.500

M 102694

aml 10/10/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 55338
Description: Pedal Bracket		Part Number: D3205-1
Inspection Dwg: D3205	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.101	—			
0.250	+/-0.010	.257	—			
R0.37	+/-0.030	R.375	—			
0.125	+/-0.010	.130	—			
0.250	+/-0.010	.256	—			
2.380	+/-0.010	2.380	—			
1.380	+/-0.005	1.377	—			
0.500	+/-0.005	.495	—			
0.880	+/-0.010	.879	—			
Ø0.470 x 100°	+0.005/-0.000	Ø.475 x 100°	—			
0.440	+/-0.005	.441	—			
0.600	+/-0.005	.604	—			
1/4-28UNF-313	N/A	1/4-28UNF	—			
0.250	+/-0.010	.248	—			
Ø0.257	+0.005/-0.000	Ø.258	—			
1.750	+/-0.010	1.750	—			
0.870	+/-0.005	.869	—			
0.440	+/-0.005	.439	—			
R0.25	+/-0.030	R.250	—			

Measured by: [Signature]	Audited by: H. A	Prototype Approval: N/A
Date: 10.01.18	Date: 10/01/18	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

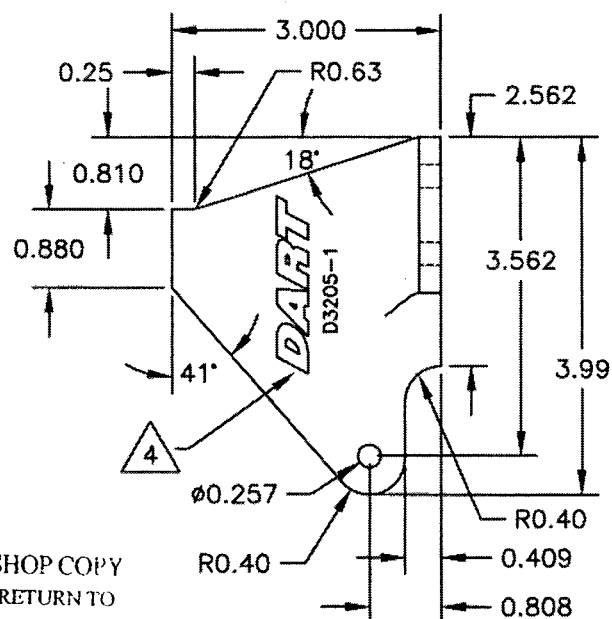
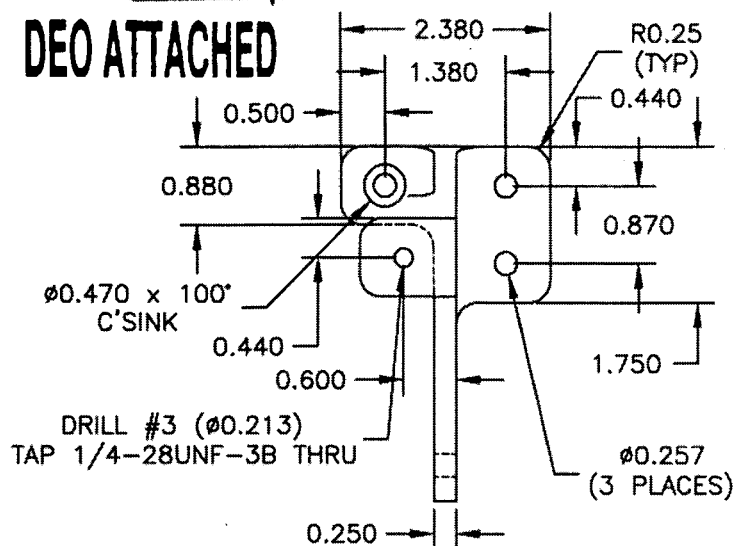
NOTE: Date & initial all entries



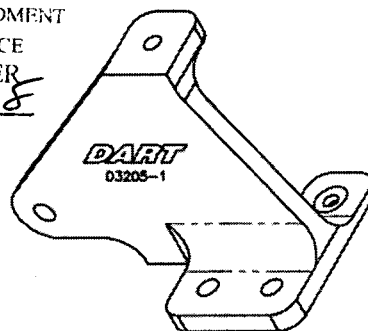
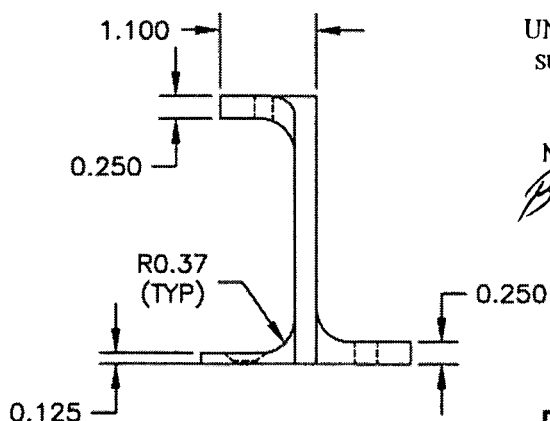
DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3205	REV. A SHEET 1 OF 2
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05

DEO ATTACHED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35338
B/10-1-13



D3205-1 PEDAL BRACKET

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

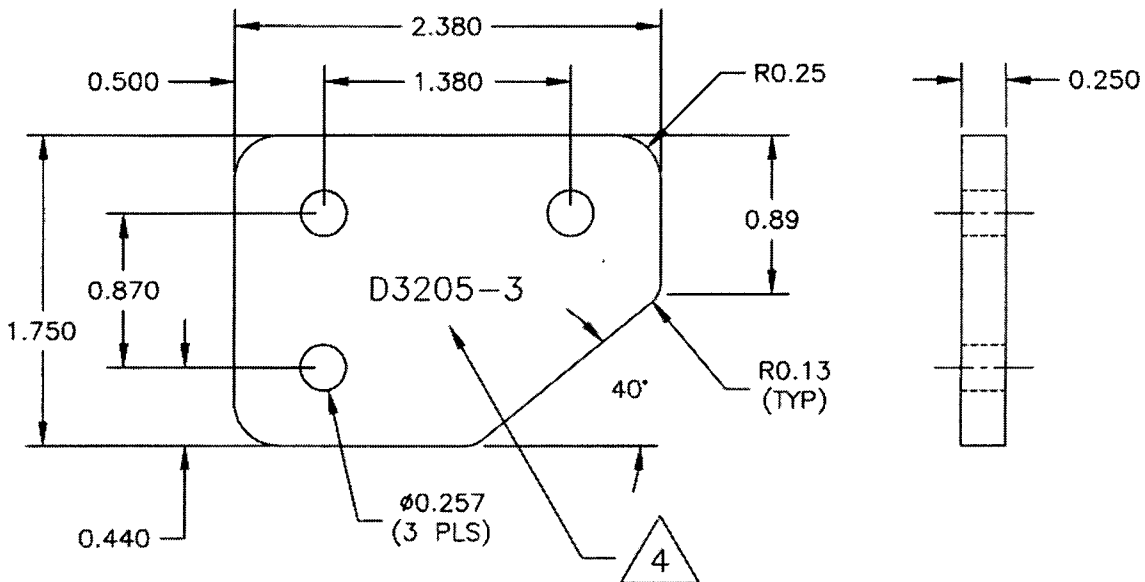
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	14	DRAWN BY	14	DART AEROSPACE LTD
CHECKED	14	APPROVED	14	HAWKESBURY, ONTARIO, CANADA
DATE	04.01.27	TITLE	D3205	REV. A
			BRACKET	SHEET 2 OF 2
				SCALE 1:1

RELEASED 04.04.05
DEO ATTACHED



D3205-3 BACK PLATE

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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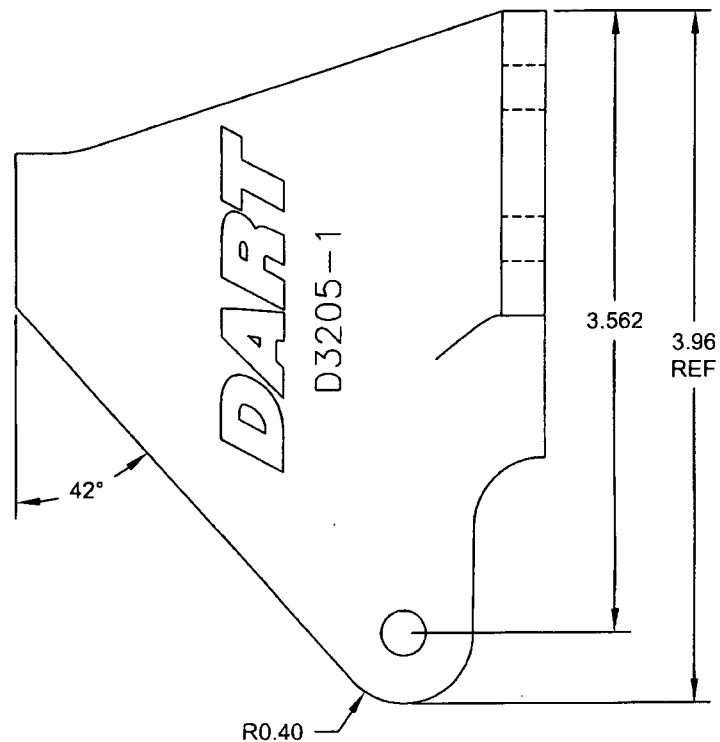
NOTE: Date & initial all entries

W/O 55338

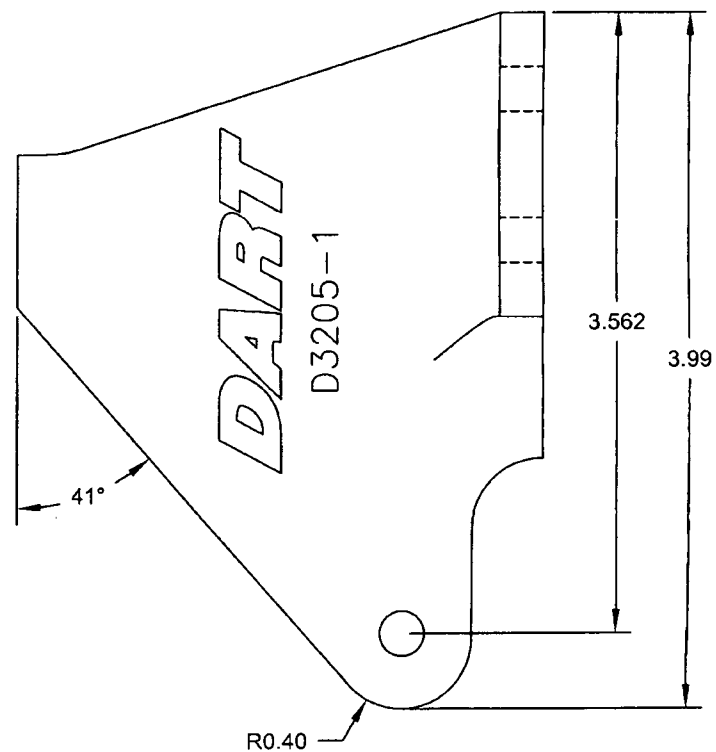
DRAWING NO. D3205	TITLE BRACKET	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3205-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.12.01	DATE 08.12.01	DATE 08/12/01	DATE 08/12/01		DATE 08.12.01		

SHEET 1 MODIFY D3205-1 AS SHOWN:

IS:



WAS:



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